

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC FAIRCHILD INTERNATIONAL AIRPORT, USA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2740	REV. B SHEET 1 OF 2
DATE 98.09.01		TITLE 350 SKIDTUBE WELDMENT	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	AS MANUFACTURED	

RELEASED
98.11.03 DS**NO LONGER APPLICABLE**

98.12.16 DS (SEE D2750 Rev. C)

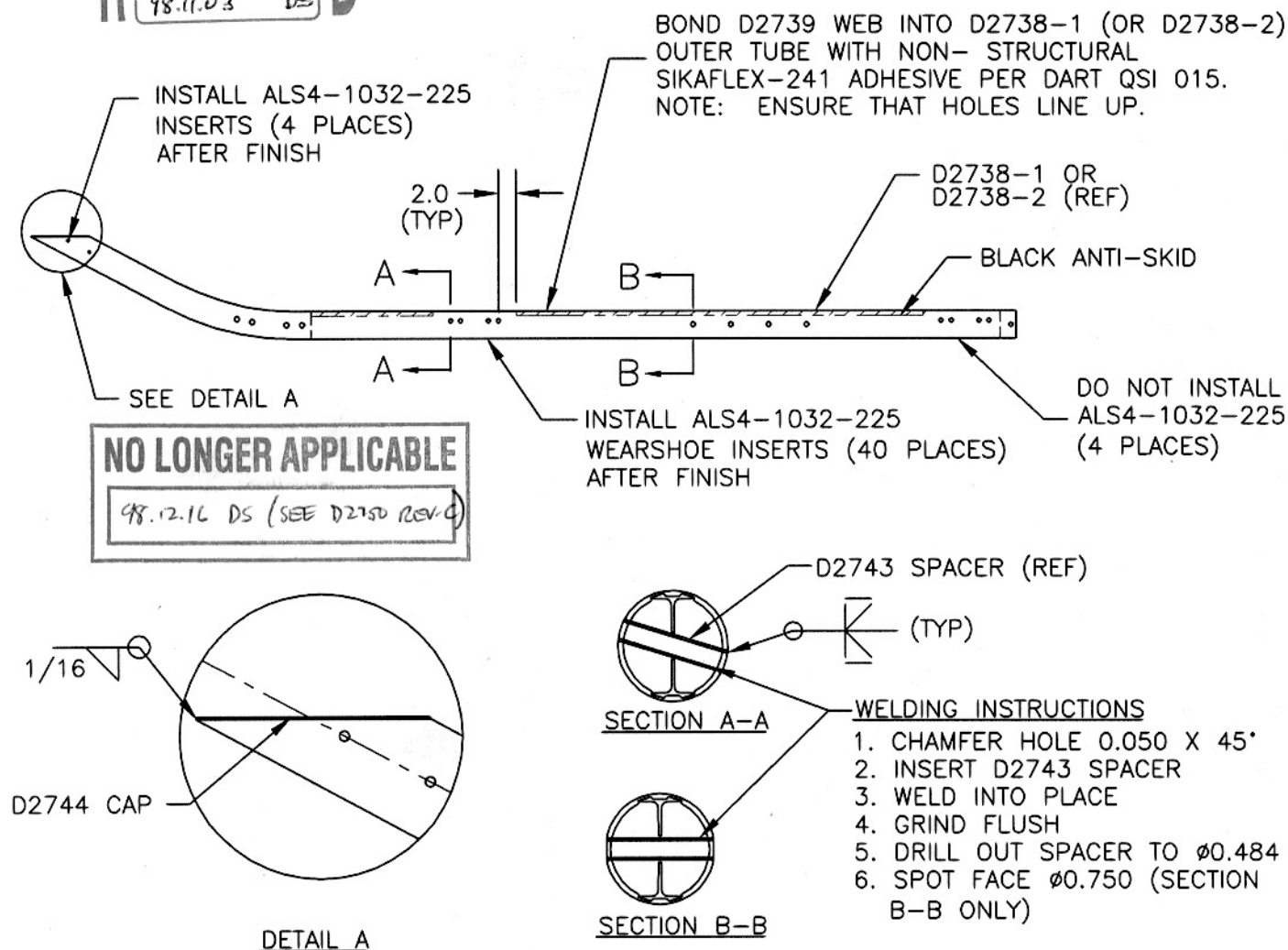
Qty -1	Qty -2	Part Number	Description
X		D2740-1	SKIDTUBE WELDMENT, LH
	X	D2740-2	SKIDTUBE WELDMENT, RH
1		D2738-1	SKIDTUBE, LH
	1	D2738-2	SKIDTUBE, RH
1	1	D2739	WEB
8	8	D2743	CROSS BOLT SPACER
1	1	D2744	CAP
44	44	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2. WELDING TO BE DONE PER DART QSI 004
3. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi

DART

DESIGN <i>HA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC FAIRCHILD INTERNATIONAL AIRPORT, USA	
CHECKED <i>HA</i>	APPROVED <i>KE</i>	DRAWING NO. D2740	REV. B SHEET 2 OF 2
DATE 98.09.01		TITLE 350 SKIDTUBE WELDMENT	SCALE NTS

RELEASED
98.11.03 DS**D2740-1 ASSEMBLY INSTRUCTIONS**

(D2740-2 CONSTRUCTED FROM D2738-2 AND D2739)

1. WELD ON D2744 CAP (SEE DETAIL A) PER DART QSI 004.
2. ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1.
3. INSTALL D2739 WEB PER INSTRUCTIONS ABOVE.
4. WELD IN D2743 SPACERS AS SHOWN IN SECTION A-A (4 PLACES) AND B-B (4 PLACES) PER DART QSI 004.
5. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
6. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART QSI 005 4.4 (OPTIONAL)
7. INSTALL ALS4-1032-225 INSERTS AS INDICATED ABOVE AFTER FINISH.